



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2366

Job Sheet 181207



Part No: D2366

Job Qty: 12 ea

Part Name: Lock Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP B 00.05.04 Reformat EC IPP Rev:C Now on Waterjet 07-04-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		8/31/18	0.00	0.00	Start Up Waterjet		SC 18/08/18
100	Waterjet	12 pcs		8/31/18	0.01	0.48	Waterjet1		SC 18/08/18
120	QC	12 pcs		8/31/18	0.00	0.00	QC8		D 18-08-21
130	Small Fab	12 pcs		8/31/18	0.00	0.30	Small Fab N/A		
140	Packaging	12 pcs		8/31/18	0.00	0.00	Packaging3		
150	QC21-SA	12 Ea		8/31/18	0.00	0.00	QC21		DAS 11.10. AUG 20 2018

Part Op 100 - 1-Cut as per Dwg 2366
Descriptions: 130 - Tumble and stock

9-89

STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	.2088 sf (.0174 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	0	371	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Handle	0.191Inches + 0.005 - 0.001	0.196 0.190	0.193 Diameter	
2	Lock Handle	0.750Inches ± 0.010	0.760 0.740	0.751	
3	Lock Handle	0.344Inches ± 0.010	0.354 0.334	0.343	
4	Lock Handle	1.196Inches ± 0.010	1.206 1.186	1.195	
5	Lock Handle	2.750Inches ± 0.010	2.760 2.740	2.752	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

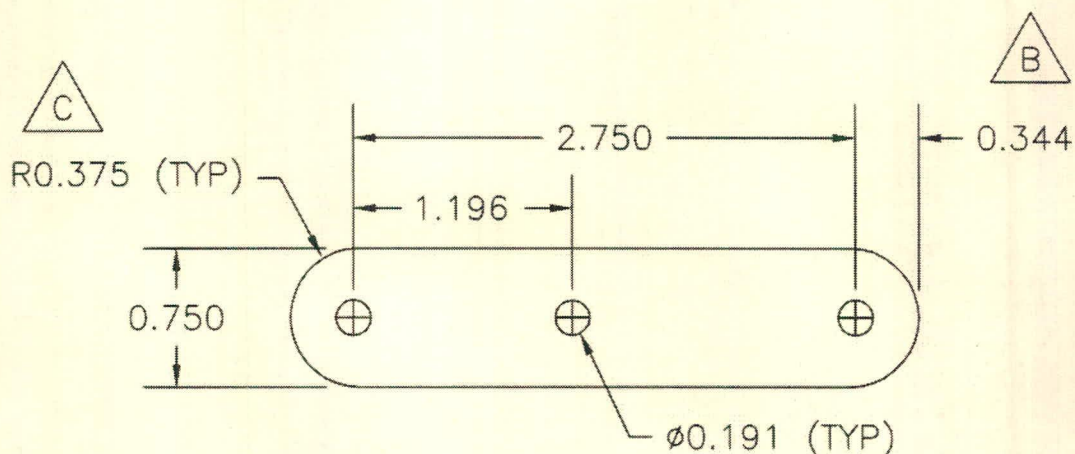
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																													
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Date : _____		Step #: _____		QTY Effective : _____		DART AEROSPACE Container No: S098069 Part: D2366 Job No: 181207 Serial No/Batch: S098069 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/01/18																																															
Description Work Order Deviation																																																					
				MRB (QSI042) Approval		Completed By																																															
				Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval																																															
Root Cause <table style="width:100%; border: none;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border: none;"> <tr><td>☐ Press</td></tr> <tr><td>☐ Bendi</td></tr> <tr><td>☐ Centre</td></tr> <tr><td>☐ Cracks</td></tr> <tr><td>☐ Crimp/I</td></tr> <tr><td>☐ Cuffs</td></tr> <tr><td>☐ Crushing</td></tr> <tr><td>☐ Heat Treat</td></tr> <tr><td>☐ Wave/Twist in Tube</td></tr> <tr><td>☐ Marks/Chatter</td></tr> <tr><td>☐ Countersink</td></tr> <tr><td>☐ Cut Too Short</td></tr> <tr><td>☐ Instructions Incomplete/Unclear</td></tr> <tr><td>☐ Drill Holes</td></tr> </table>		☐ Press	☐ Bendi	☐ Centre	☐ Cracks	☐ Crimp/I	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	<table style="width:100%; border: none;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Dimensions</td></tr> <tr><td>☐ Over/Under tolerance</td></tr> <tr><td>☐ Part Incorrect</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Part Moved</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Misread</td></tr> <tr><td>☐ Turning Sequence</td></tr> </table>		☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2366	REV. C SHEET 1 OF 1
DATE 00.04.24		TITLE LOCK HANDLE	SCALE 1:1
A	95.02.20	NEW ISSUE	
B	96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300	
C	00.04.24	R0.375 WAS R0.50	

RELEASED
00 05.02 #



MATERIAL: AISI 304/316 SS 0.040 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE INCHES

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